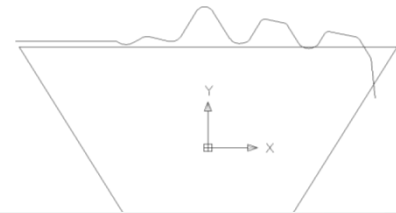


Doublesided Triangle Insert Ø20 Z2

A8-200








The triangular Insert is clamped using the PPC System (Precision Pin Clamping). All 3 sides are free for any grinding of profile or chipbreaking operations. Profilegrinding is based on the VSW grinding technology, where the sides of the V-shaped wheel fit tangential to the straight faces and convex parts of the profile.



1. Cycletime for production

Toolspecifications

Diameter 20 mm, Cutting edges 2, Length of cutting edge 18 mm
Material HM

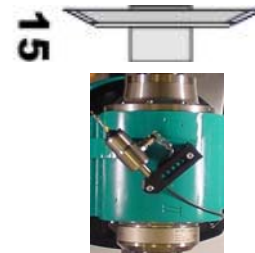
Operations				
	Probe	Prf Pregr	Prf fin	Chipbreaker
Feed [mm/Min]	2000	50	70	100
Power [kW]		1	1	1
Cutting feed [m/s]		18	22	24
Used wheels				
Grinding time [s]	30	156	113	102
Total cycle time	6 Min 40			

The mentioned cycle times are indicative. The material to be ground, other grinding wheels and other coolants can influence the cycle times considerably.



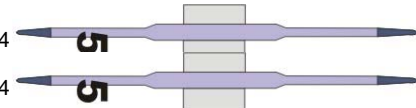
2. Used grinding wheels

Ø125 1V1 D64



Ø300 14EE1 V40 D64

Ø300 14EE1 V40 D64



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : CORVUS GDS, GEMINI DMR, NORMA CFG
Control: Fanuc 31i
Coolant: Synthetic Oil, pressure 6 - 7 bar
Software: Quinto 5

responsible engineer: W. Sitez, 22.1.07

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TECHNOLOGY
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